

Date: Thursday, 01/05/2008 10:03:54 AM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SUPPORT ASSEMBLY		
Job Number	: 38929			Part Number	: D3278041		
Estimate Number	: 10464			Drawing Number	: D3278 REV.C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 01/05/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: 01/05/2008 Type : SMALL /MED FAB			Due Date	: 20/05/2008 Qty: 40 Um: Each		
Previous Run	: 37780						
Written By	:						
Checked & Approved By	: JLD 08.5.01						
Comment	: Est:A 04.04.19 New issue KJ/JLM EST B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D32781	Support	✓
			<i>B 35593 X 10 B 36811 X 42 &gt; 52 ml</i>
2.0	D32782	Support	✓
			<i>B36119 B X 11 B 36811 B X 41 &gt; 52 ml</i>
3.0	D32783	Spacer	
			<i>B34956 X 18 B 38935 X 34 ml</i>
4.0	MS20426AD36	Rivet	
			<i>208 RIVET 08/05/05 ml</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

~~Part No:~~ \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
~~QA: N/C Closed:~~ \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 10:03:54 AM  
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Drawing Name: SUPPORT ASSEMBLY

Job Number: 38929

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



x52

Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet spacers with support as per Dwg D3278.

6.0 QC5 INSPECT WORK TO CURRENT STEP



counte

Comment: INSPECT WORK TO CURRENT STEP

7.0 D22301 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s) 104

Mounting Lug

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2230-1	Mounting Lug	

9 x B 38740 ✓  
80 x B 37745 ✓  
15 x B 36747 ✓

ml

8.0 AN413A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s) 104

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4-13A	Bolt	m107321

ml

9.0 AN960JD416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 160.0000 Each(s) 208

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	AN960JD416	Washer	m107321

✓

ml

10.0 MS21042L4 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s) 104

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	MS21042L4	Nut	m106051

✓

ml  
08/05/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 38929

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

\*\*\*DO NOT TIGHTEN BOLTS\*\*\*

Identify as D3278-041

X52

ml08/05/09

12.0 QC5

INSPECT WORK TO CURRENT STEP



Counts

S 08/05/09 X52

Comment: INSPECT WORK TO CURRENT STEP

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

STY71

L 08/05/09 52

14.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

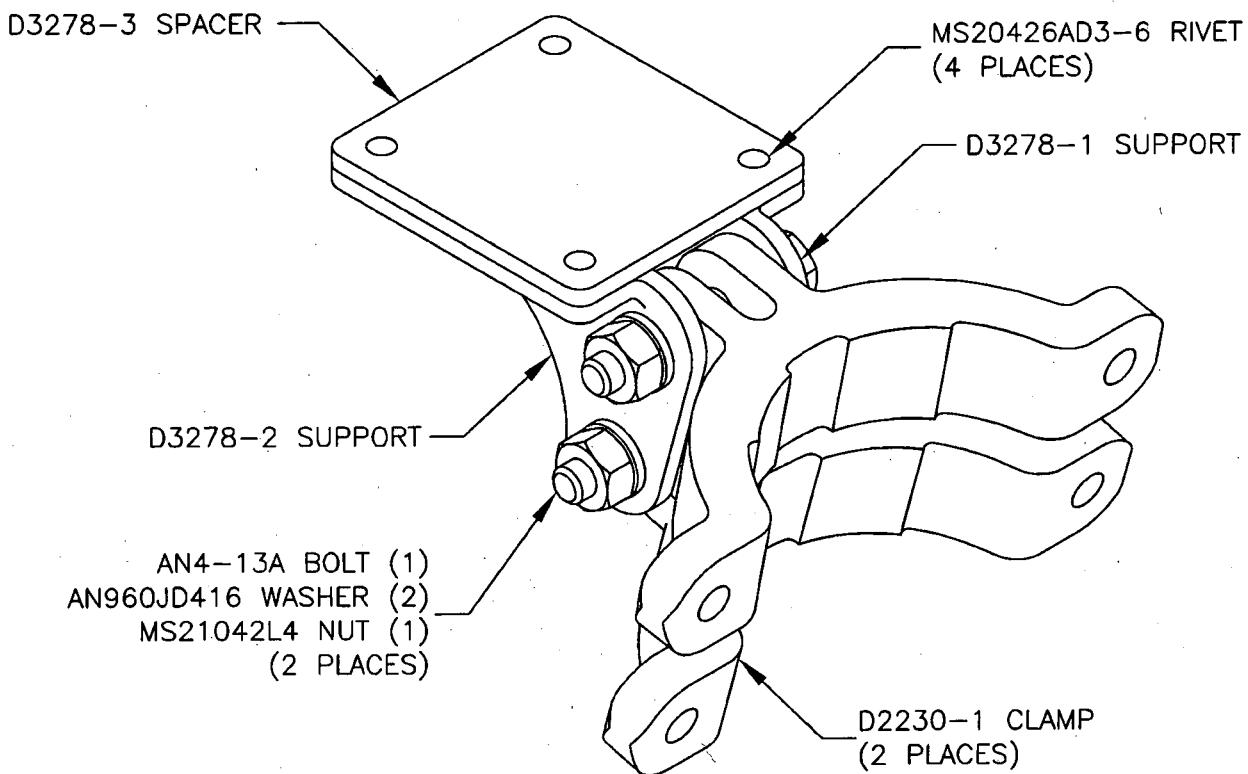
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>9P</i>	DRAWN BY <i>JG</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278
DATE 07.07.24	TITLE SUPPORT ASSEMBLY	SCALE NTS

**RELEASED**  
07.08.08D3278-041 SUPPORT ASSEMBLY

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

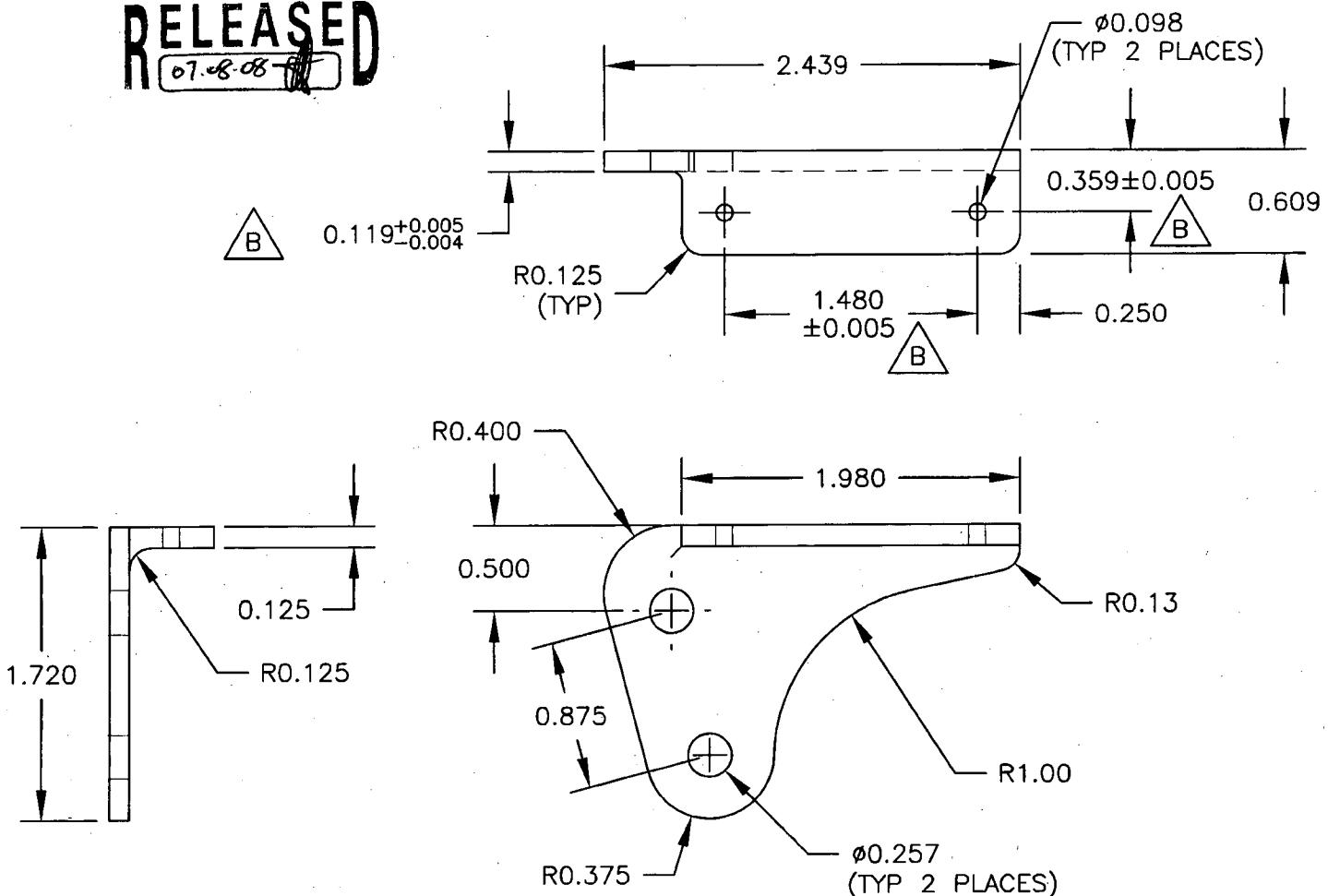
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WITHOUT NOTICE  
WORK ORDER  
NO. 38929

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**DART**

DESIGN <i>QP</i>	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C	SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1	

**RELEASED**  
07-08-08**D3278-1 SUPPORT (SHOWN)**  
**D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPR"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

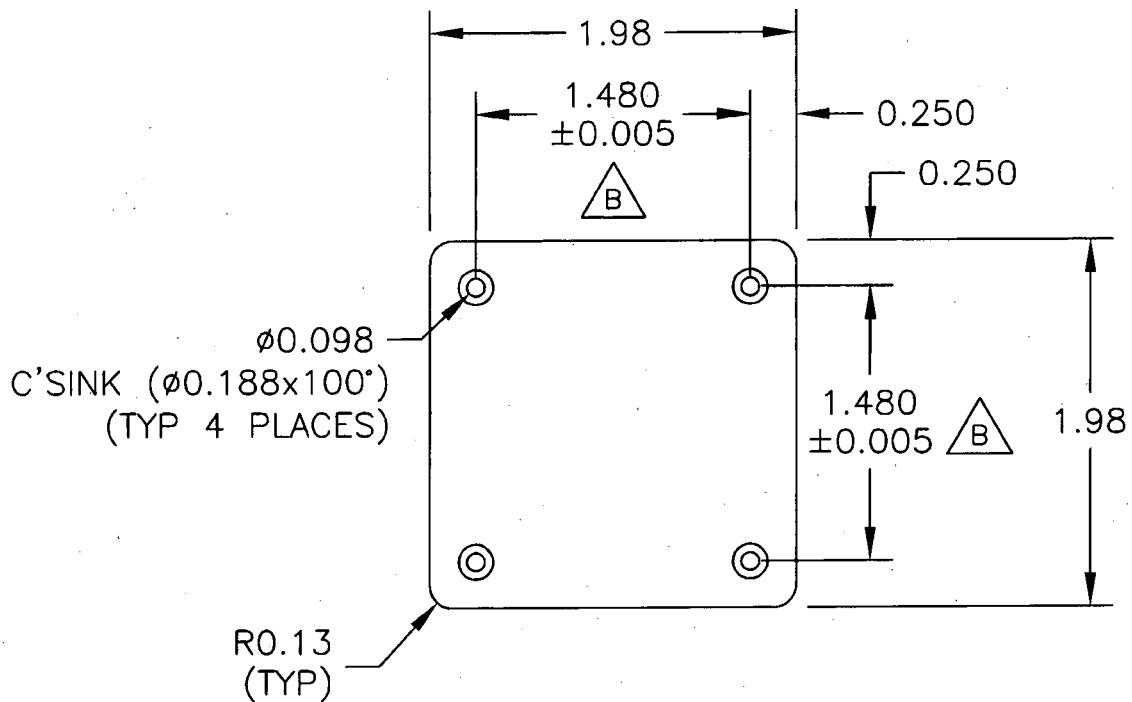
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**DART**

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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WORK ORDER

NO. 38929